

SHIP TODAY 10/08/09

Work Order ID 61027

August 4, 2010 10:18:52 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4079-1
Revision ID: PRELIM
Item Name: Clamp Half, Attachment

Accept



Setup Start



Stop



Start Date: 04/08/2010 Start Qty: 2.00

Required Date: 10/08/2010 Req'd Qty: 2.00



Cust Item ID:

Customer:



Reference: *10-08-04*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4079	<i>PA1</i>

100 *PA2 10-08-09* 0.00



Bandsaw Memo 0.00 *8/10/08/08* 2 8

Jeaspa Bandsaw Cut blank 2.750" long

110 0.00



HAAS I Memo 0.00 *8/10/08/09* 2 0

HAAS CNC vertical machine #1 Mill as per Dwg and Folio FA931

Folio rev: AA
Dwg Rev: B

Debur

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Page 2

Item ID:	D4079-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Clamp Half, Attachment					
Start Date:	04/08/2010	Start Qty:	2.00			
Required Date:	10/08/2010	Req'd Qty:	2.00			
Reference:	<i>10.08.04.</i>					
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		<i>28 10/08/09</i>		<i>2</i>	<i>0</i>		
130 QC Quality Control	QC8- Inspect parts - second check Memo <input type="checkbox"/>	0.00 0.00		<i>- inspected & Prod Dry only</i> <i>8/10/09</i>					
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>ml</i>	<i>10</i>	<i>08</i>	<i>09 (2)</i>

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Item ID:	D4079-1	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Clamp Half, Attachment					
Start Date:	04/08/2010	Start Qty:	2.00			
Required Date:	10/08/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	M112588 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 START: 11:30AM Memo TEMP: 320°F FIN: 12:00P~	0.00 0.00		10/08/09		X2	Ø		
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							10/8/9 sp (2x)
170 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							10/8/9 sp 2x

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Item ID: D4079-1

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Revision ID: PRELIM

Stop



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Start Date: 04/08/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/08/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10-8-9 AUTH MF

RELEASED _____ DATE _____

MF
10-8-9

RD 1336 Ave

Picklist Print

August 4, 2010 10:18:52 AM

Page 1

Work Order ID: 61027



Parent Item: D4079-1



Parent Item Name: Clamp Half Attachment

Start Date: 04/08/2010

Required Date: 10/08/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 10*-05-10 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	41.9978	0.23	0.484211			



6061-T6 Bar 2.00 x 2.00



Location

Loc Qty

Loc Code

MAT09

41.9978

113006

20

113123

12.9978

13085

9

.4843

8/10/08/08

DART AEROSPACE LTD		Work Order: 61027
Description: clamp Half Attachment		Part Number: D4079
Inspection Dwg: D4079 Rev: PA2 PA2		Page 1 of 1

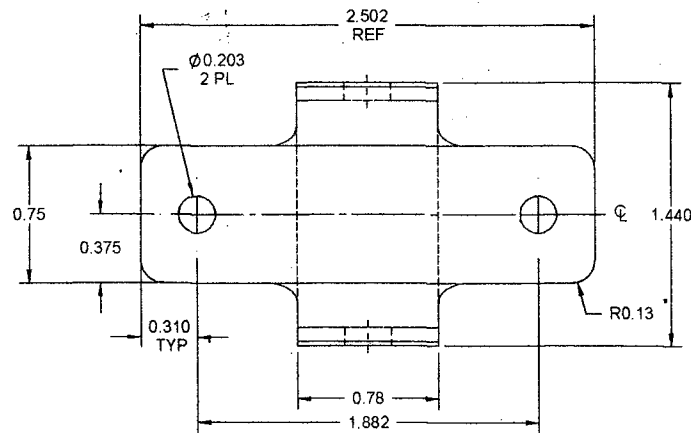
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.75	±.030	.748	✓		V SF12	
.78	"	.784	✓		"	
.23	"	.227	✓		"	
.60	"	.595	✓		"	
1.65	"	1.650	—		High gauge	
2.502	±.010	2.504	✓		V SF12	
1.440	"	1.445	—		"	
1.882	"	1.879	✓	—	"	
.310	"	.310	✓		"	
.375	"	.375	✓		"	
.025	"	.025	✓		High gauge	
.850	"	.845	✓		V SF12	
.390	"	.390	✓		"	
1.240	"	1.241	✓		"	
.100	"	.098	✓		"	
R.050		.062	—		Rad gauge	
R.130		.125	—		"	
R.730		—	✓	—	✓	
R.025		.250	✓		Rad gauge	
0.38	±.010 ±.000	.385	✓		High gauge	
Ø.203	±.005 ±.001	.203	✓		V SF12	
Ø.257	±.006 ±.001	.257			"	

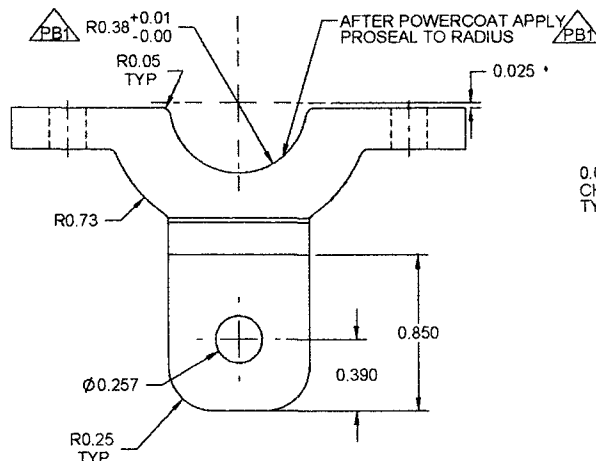
Measured by: <i>SP</i>	Audited by: <i>S</i>	Preliminary Approval:
Date: 10/08/09	Date: 10/08/09	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

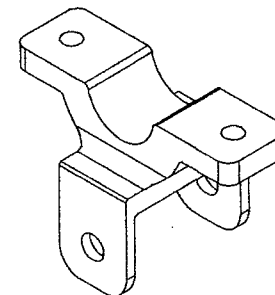
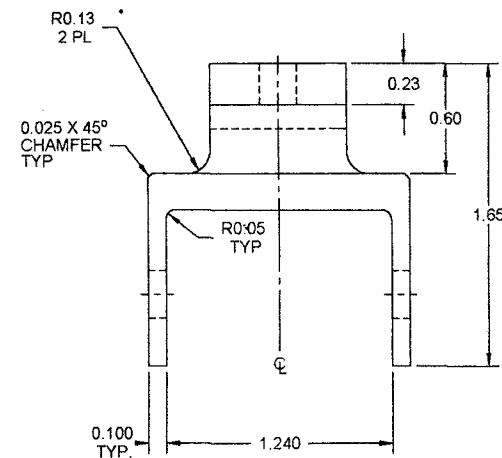
10.04.15



GRAIN
DIRECTION



D4079-1 CLAMP HALF, ATTACHMENT



NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4079-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.09 lbs

REV.	R0.38 WAS R0.48, ADDED PROSEAL NOTE	JB	10.07.30	
	NEW ISSUE	JB	10.02.08	
REV.	DESCRIPTION	BY	DATE	
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JB			
CHECKED	JB			
MFG. APPR.	JB			
APPROVED	JB			
DE APPR.	JB	CLAMP HALF, ATTACHMENT NTS		
DATE	10.07.30			
DRAWING NO. D4079				REV. 1
TITLE				SHEET 1 OF 1
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w/o 61027

PA 2

PA 2
10/8/19

Kim Johnston

From: David Shepherd [dshepherd@dartaero.com]
Sent: Wednesday, August 11, 2010 6:46 PM
To: 'Kim Johnston'
Subject: RE: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Yes ... They will be scrapped afterwards or used for Show purposes.

David

-----Original Message-----

From: Kim Johnston [mailto:kjohnston@dartaero.com]
Sent: Tuesday, August 10, 2010 9:02 AM
To: David Shepherd
Subject: prelim work orders, D4079-1 B61027 and D4078-1 B61029

Hi David,

I have two prelim work orders, D4079-1 B61027 and D4078-1 B61029. Mike tells me that they were sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after. I'll attach your email to the work orders and file them. Thanks,

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: kjohnston@dartaero.com
Tel: 613-632-5200
Fax: 613-632-9311

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.441 / Virus Database: 271.1.1/3061 - Release Date: 08/09/10 18:35:00